

WORK ORDER 2008-03

Date opened: 6 February 2008

Project: Quick Release Cargo Basket Assembly
Type: Eurocopter AS350/355 Series

Batch Quantity: 1 Complete Basket Assembly (77610-02)

Approval: Pending 5/10/08-16
Drawing List: DCL776-3

Fabrication and Assembly Drawing(s)	Description
77610, Rev. 0	Basket Ass'y
77611, Rev. 0	Basket Body Ass'y
77612, Rev. 0	Basket Lid Ass'y
36255, Rev. 1	Handle Installation
36261, Rev. 4	Handle Bar Ass'y
36262, Rev. 1	Handle Bracket Ass'y

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: _____

Jeff Clarke
Inspector Signature:

April 11/08
Date:

Drawing: 77610 Revision 0
 Assembly: 77610-02 Cargo Basket Ass'y (Quick-Release, Short, 61.25" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	77610-02	Cargo Basket Assembly			
1	77611-02	Basket Body Assembly	Below		
1	77612-02	Basket Lid Assembly	Below		
1	36255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	7005	
1	MS20001P4	Piano Hinge		7038	
1	77628-01	Placard	0.063 Sheet, 6061-T6 Aluminum	960708	
3	49205-14	Bumper	Argus Industries Bumper	6038	
A/R	CR3213-4-02	Cherry Rivet		8020	
4	40088-14	Fitting	Ancra	6058	
4	AN960-616	Washer		6016	
1	AN3-15A	Bolt		6016	
1	AN3-17A	Bolt		6066	
4	AN960-10	Washer		6043	
2	AN970-3	Washer		5026	
2	MS21044N3	Nut		6016	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-4-02 Rivets		gc.
Final Inspection	Drawing 77610			gc.

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 77611 Revision 0
 Assembly: 77611-02 Basket Body Ass'y (Quick-Release, Short, 61.25" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	77611-02	Basket Body Assembly			
2	76421-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
2	76422-01	Attachment Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
A/R		Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
1	36262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	951108	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		<i>JP</i>
Powder Coat	Drawing 77611			<i>JC</i>
Final Inspection	Drawing 77611			<i>JC.</i>

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Drawing: 77612 Revision 0
Assembly: 77612-01 Basket Lid Ass'y (Quick-Release, Short, 61.25" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	77612-02	Basket Lid Assembly			
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	951108	
1	36262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9516042	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		JP
Powder Coat	Drawing 77612			gc.
Final Inspection	Drawing 77612			gc.

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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36255-01	Handle Installation			
1	36261-01	Handle Bar Assembly	Below		
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	7004	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	6068	
2	AN3-14A	Bolt		6071	
4	AN960-10	Washer		6043	
2	MS21044N3	Nut		6016	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 36255			gc.

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Drawing: 36261 Revision 4
Assembly: 36261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	6006	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	7006	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	2005	
2	MS20615-4M3	Rivet		7039	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		AP
Final Inspection	Drawing 36261			gc.

Tag incomplete parts with Work Order # when stored between processes.

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Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36261-01	Handle Bracket Assembly			
1	36272-01	Basket Bracket	321 Stainless, 0.050 Sheet	3021	
2	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	3021	
2	36275-02	Support	304 Stainless, 5/16" Rod	6003	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36262			jc.

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket (Short) Part #: 77610-02

Approval #: SH08-16 Serial #: 77602-01

WO #: 2008-03 Quantity: 1

Eligibility: Eurocopter AS350 / AS355 Series Work Status: Manufactured

Remarks: _____

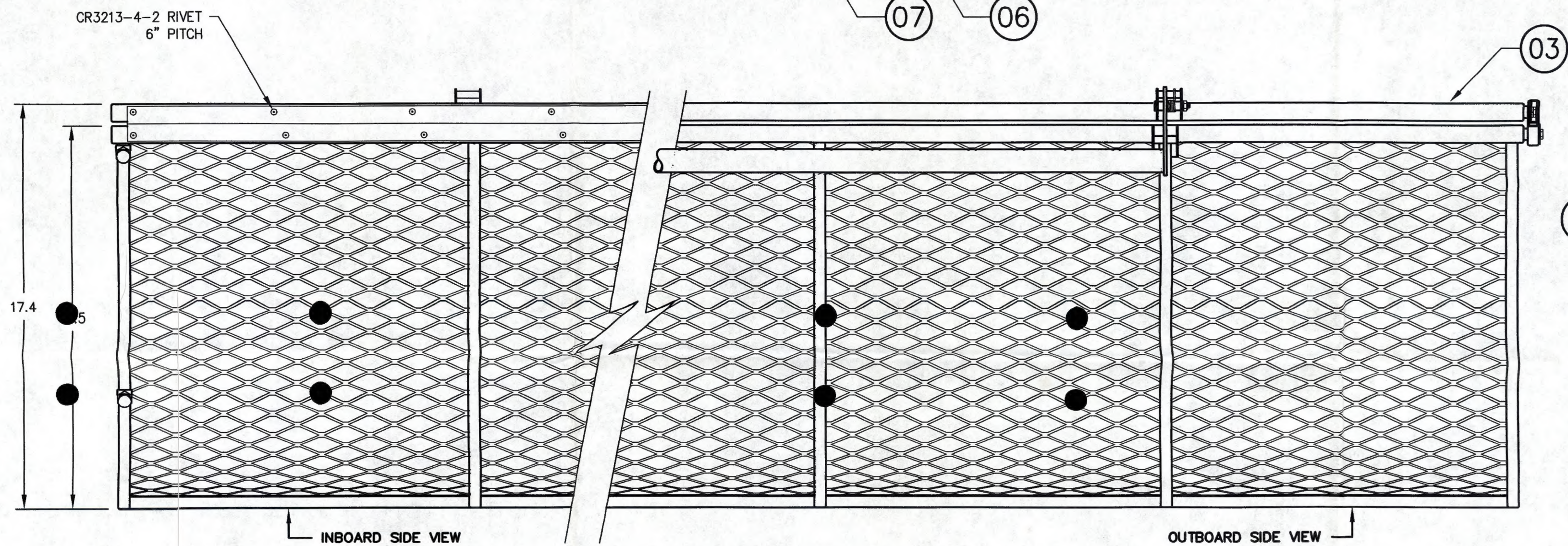
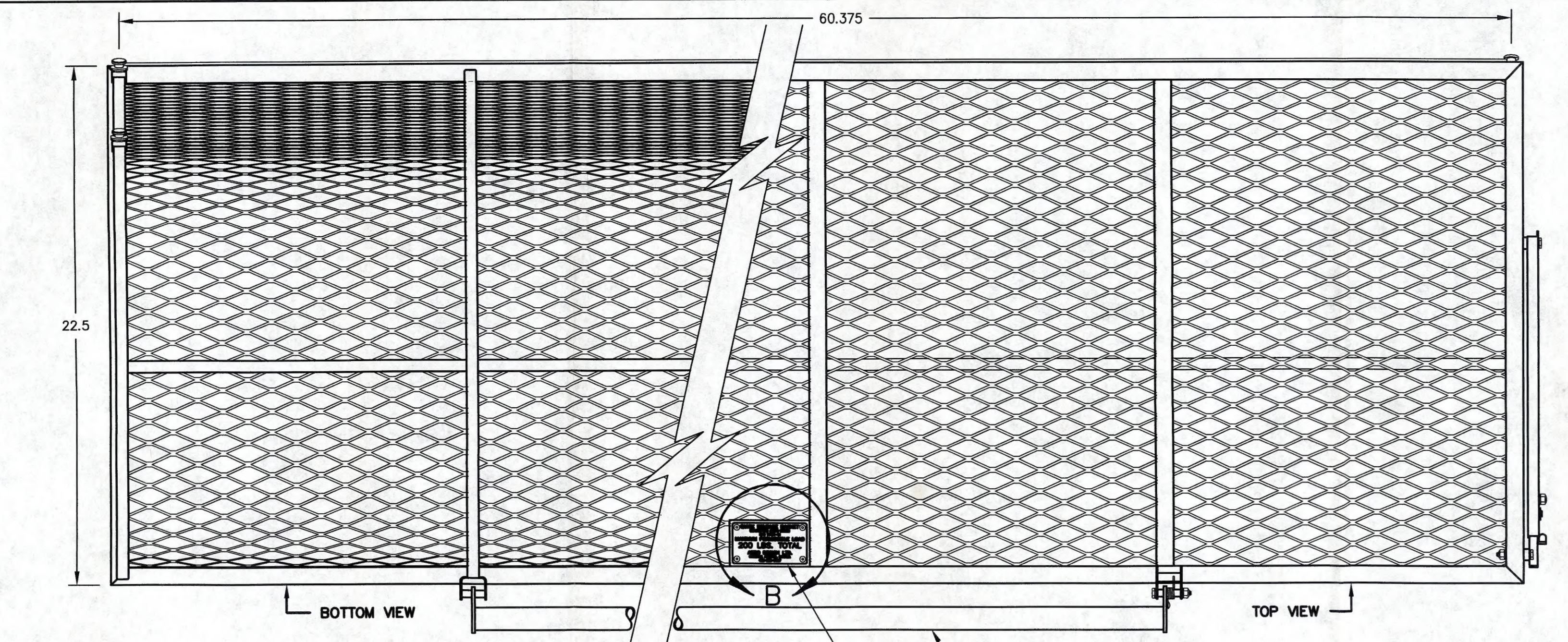
I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

April 11/08
Date

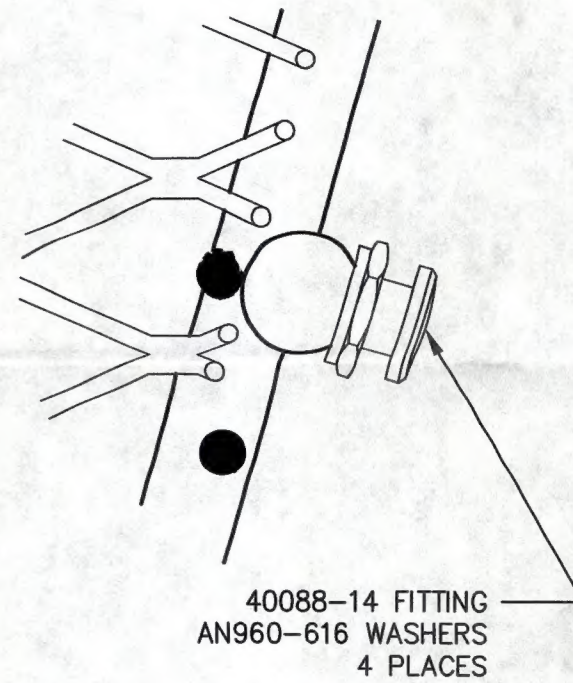
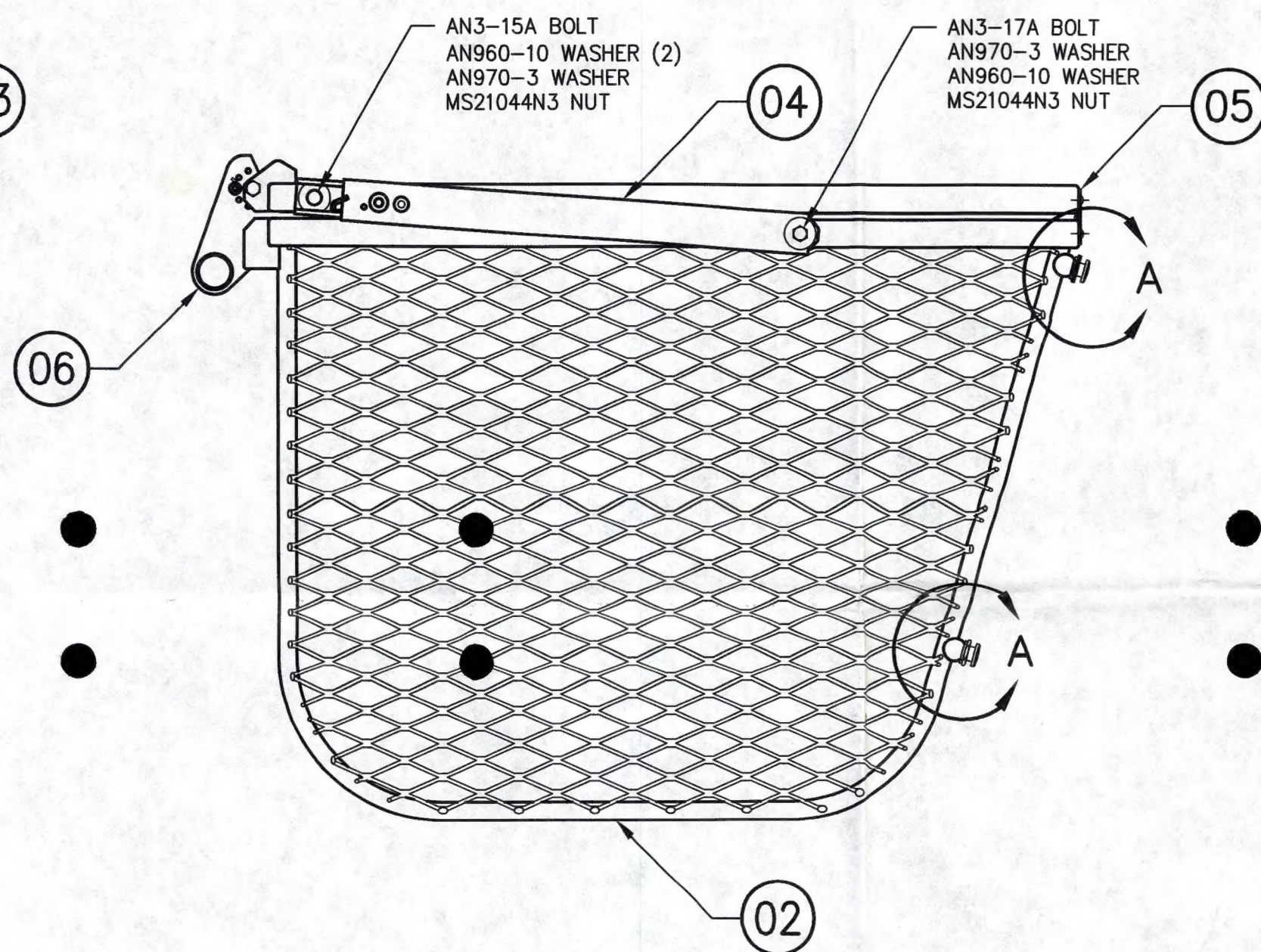
[Signature]
Inspector's Signature

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



01 CARGO BASKET ASSEMBLY

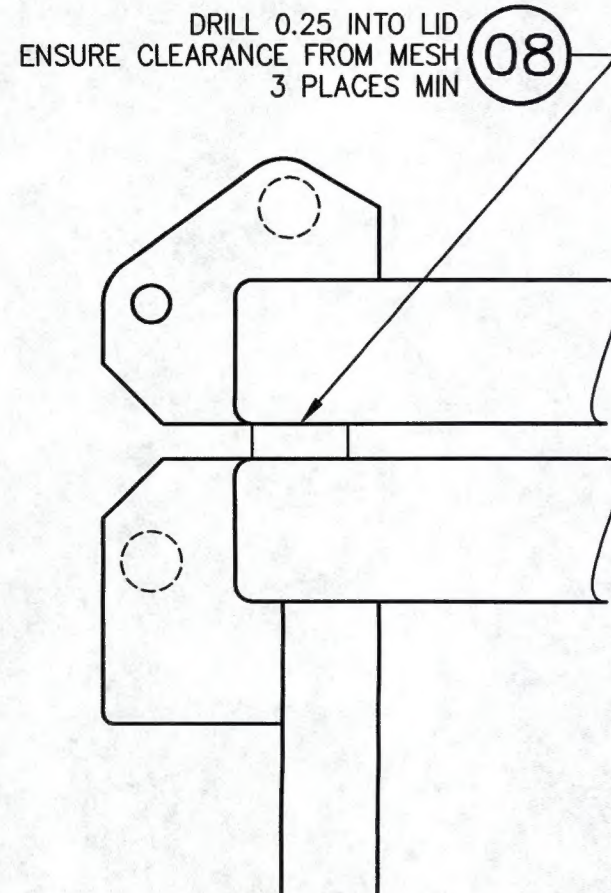


DETAIL A

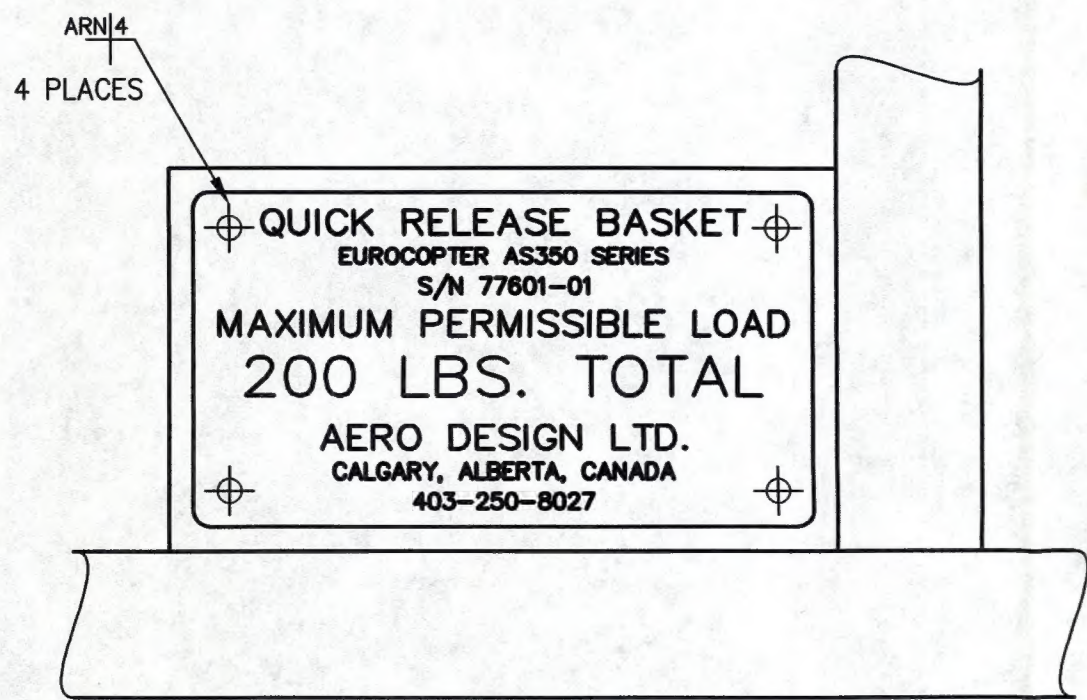
SCALE 1 : 1
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
TYPICAL FRONT AND REAR

NOTE:

1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.



BUMPER INSTALLATION
SCALE 1 : 1



DETAIL B

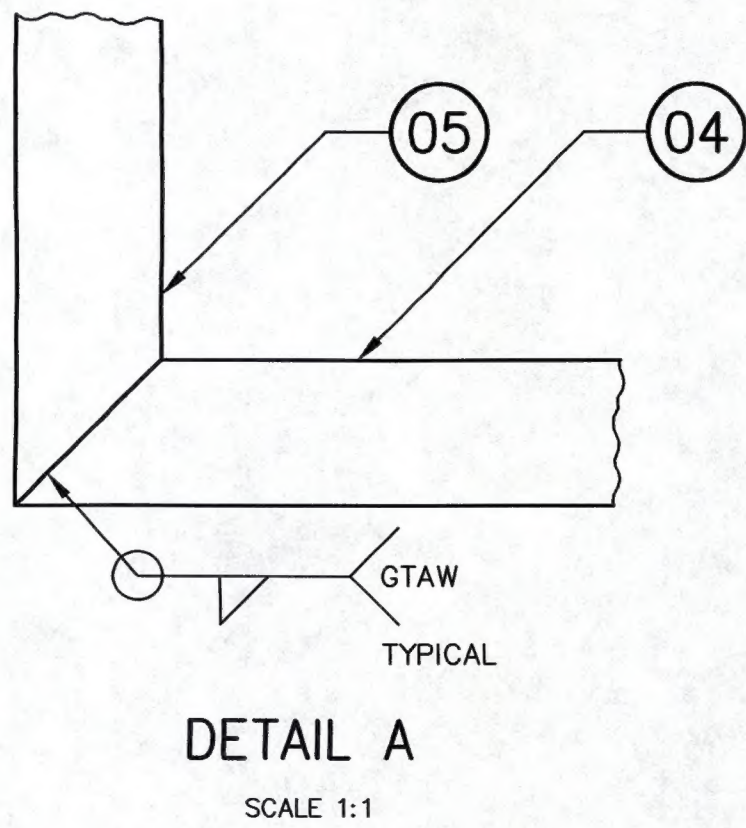
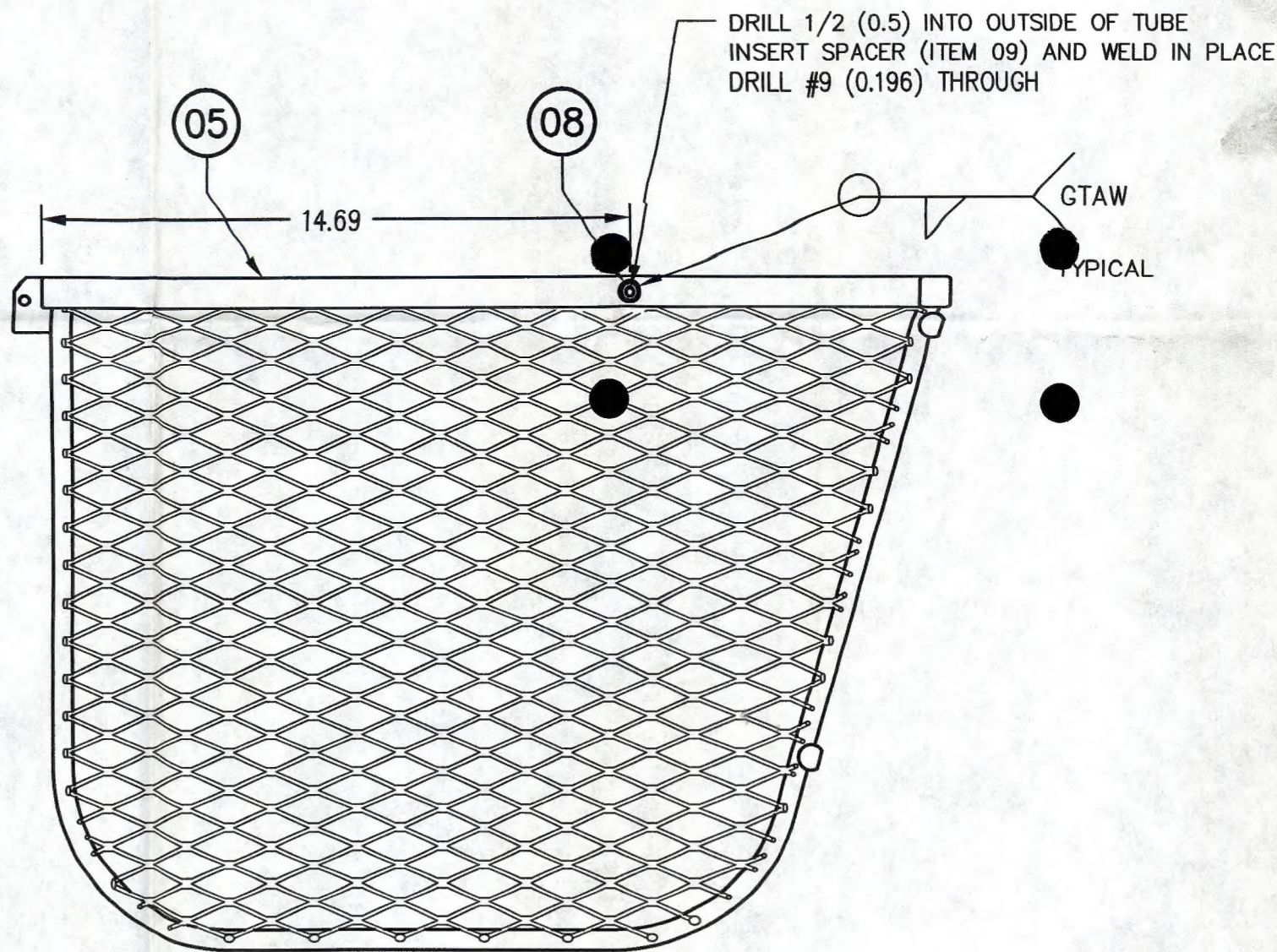
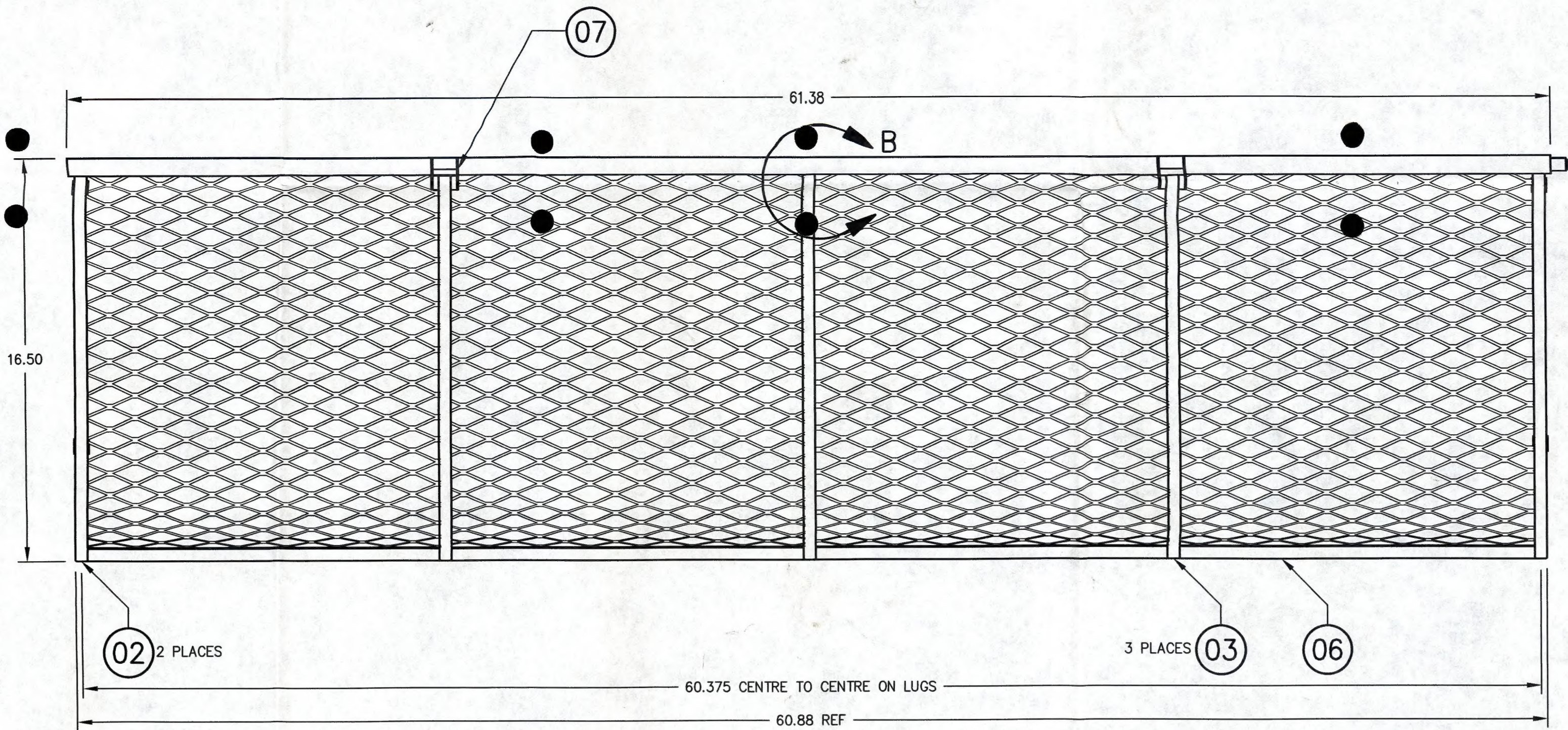
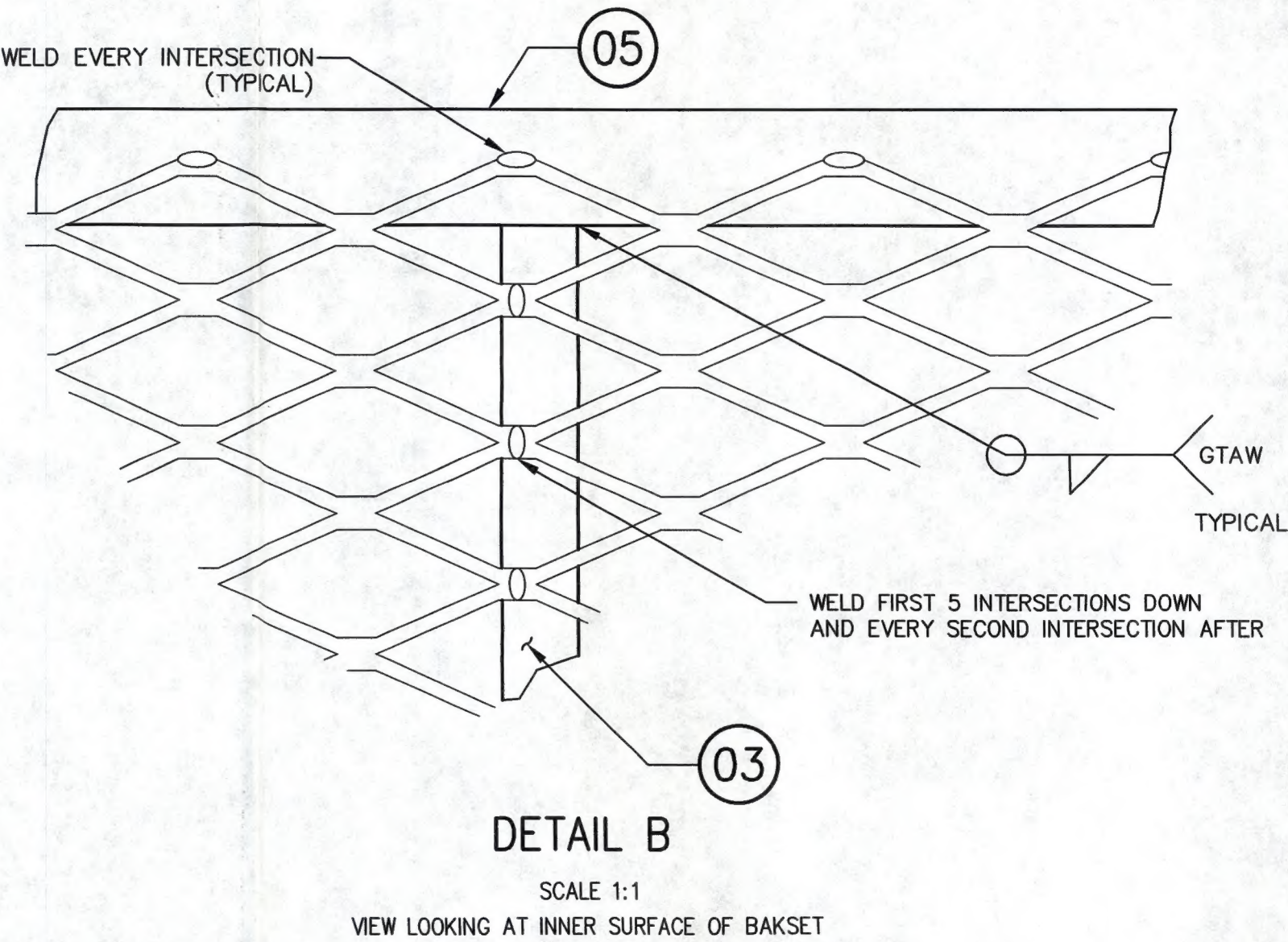
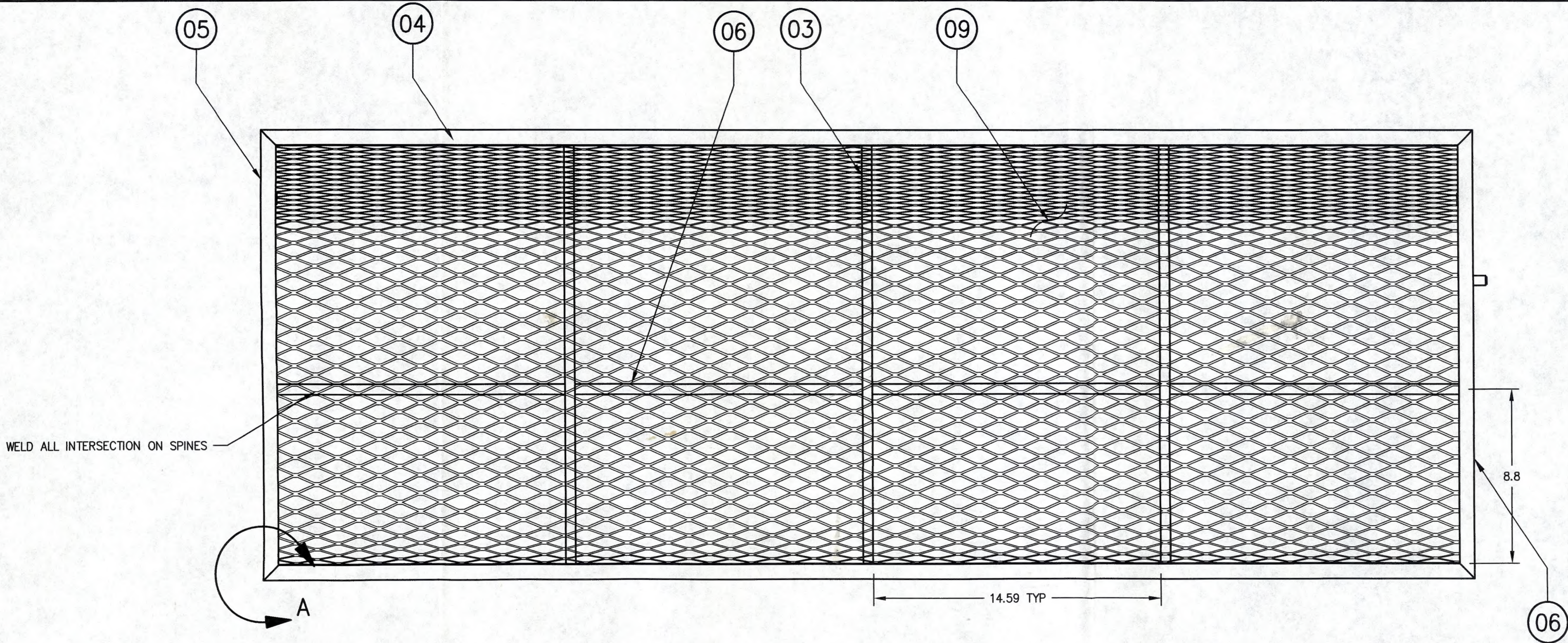
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

A/R	AN960-616	WASHER				
4	40088-14	FITTING	ANCRA			
A/R	CR3213-4-02	CHERRY RIVET				
3	49205-14	08 BUMPER	ARGUS INDUSTRIES			
1	77627-01	07 PLACARD				
1	36255-01	06 HANDLE BAR INSTALLATION				
1	MS20001P4	05 PIANO HINGE			6 FEET LONG	
1	36280-01	04 BRACE ASSEMBLY				
1	77612-01	03 LID ASSEMBLY				
1	77611-01	02 BASKET BODY ASSEMBLY				
	77610-01	01 CARGO BASKET ASSEMBLY				
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

LIST OF MATERIALS

BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE	AERO DESIGN LTD.			
REF. NAS 523	N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE	DRAWN: JEFF CLARKE	30 NOV 2007	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca			
C=COUNTERSUNK	D=DIMPLE	CHECKED: E. BURGOIN		EUROCOPTER AS350 SERIES QUICK RELEASE CARGO BASKET BASKET ASSEMBLY			
DIGIT=# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARN=CR3213 ARM=CR3212	+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET	DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1	ANGLES ±1/2°	SHEET 1 OF 1	A1	77610	0

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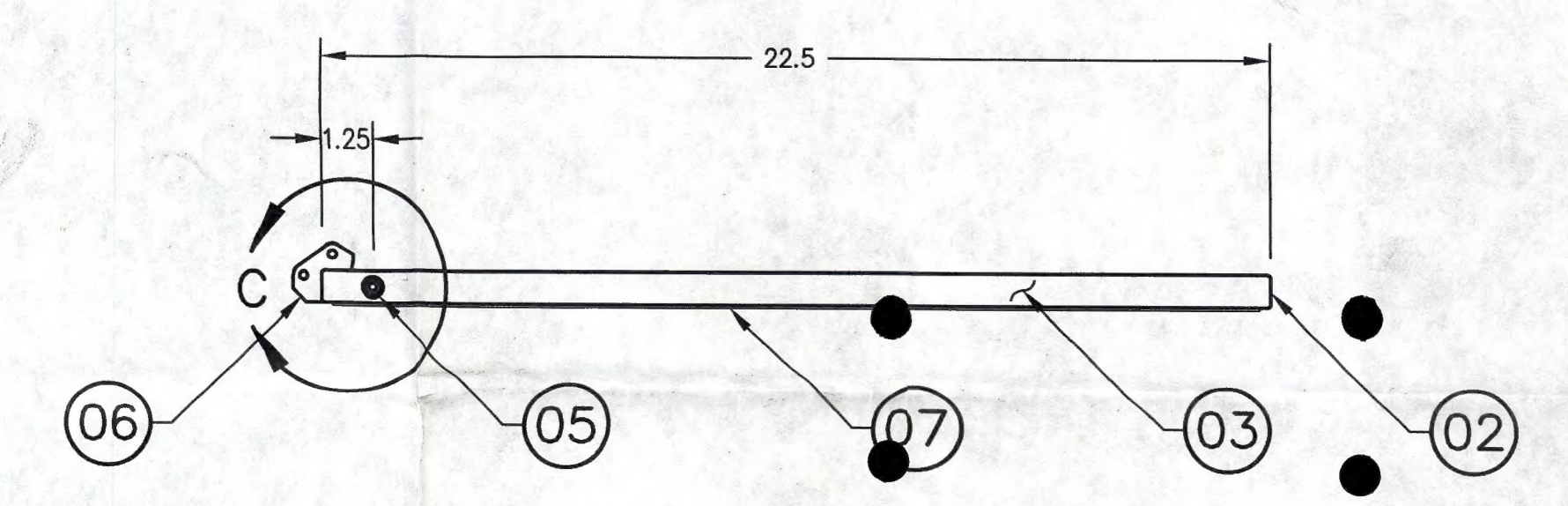
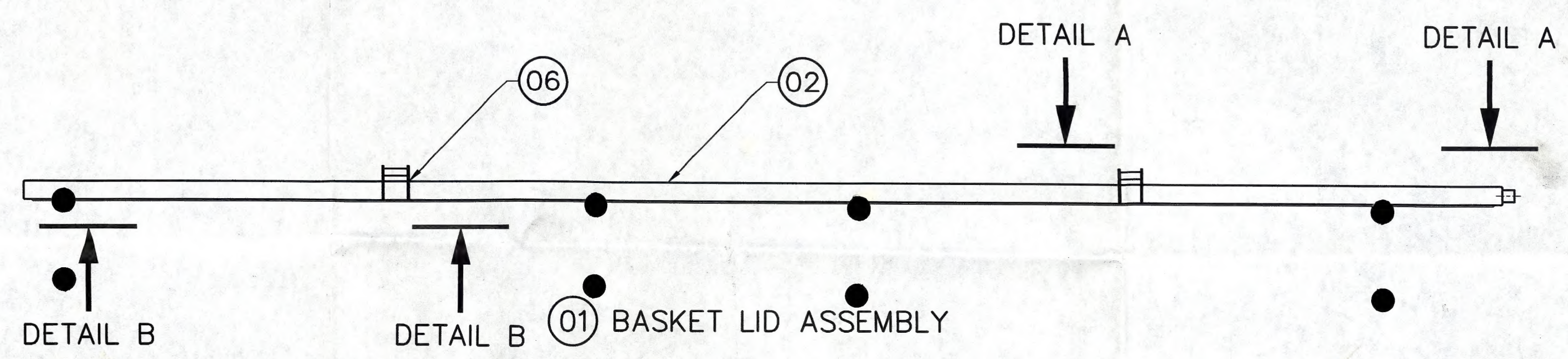
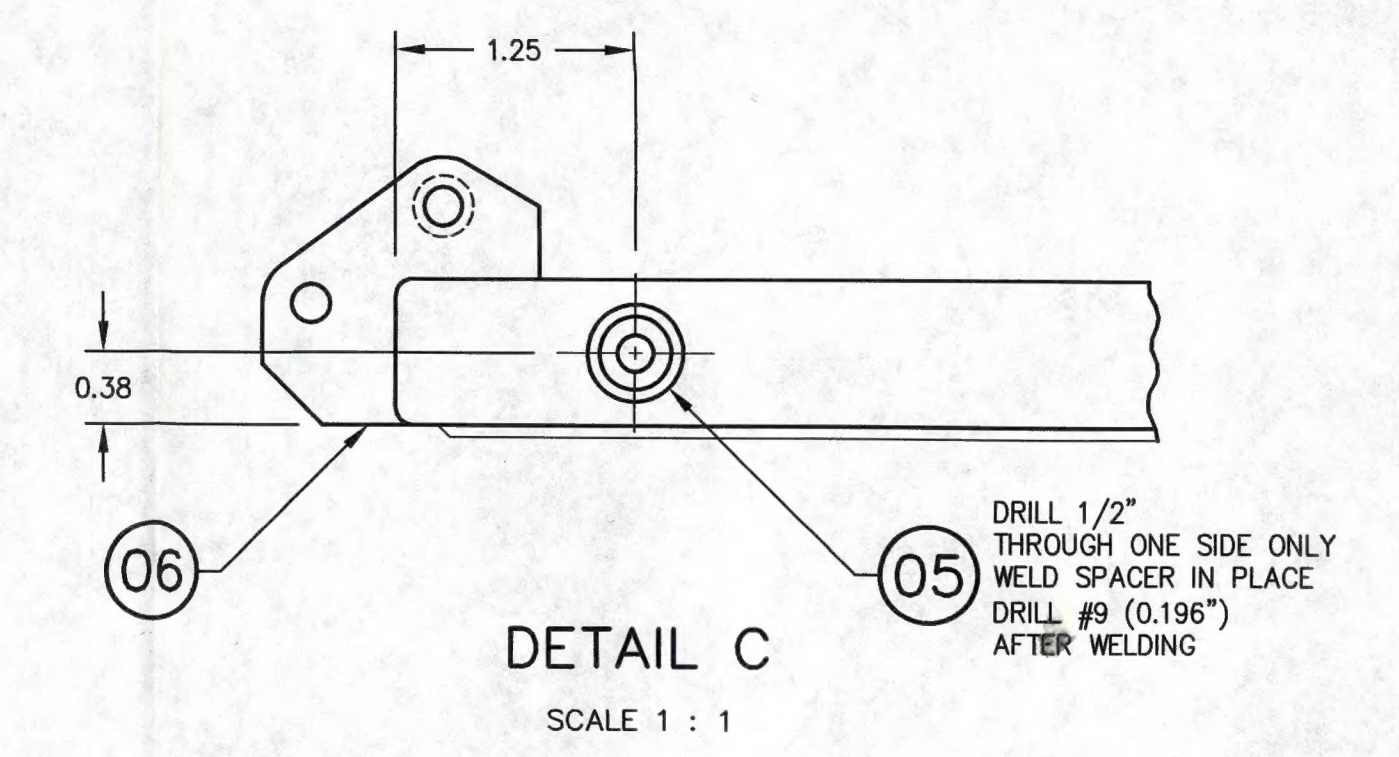
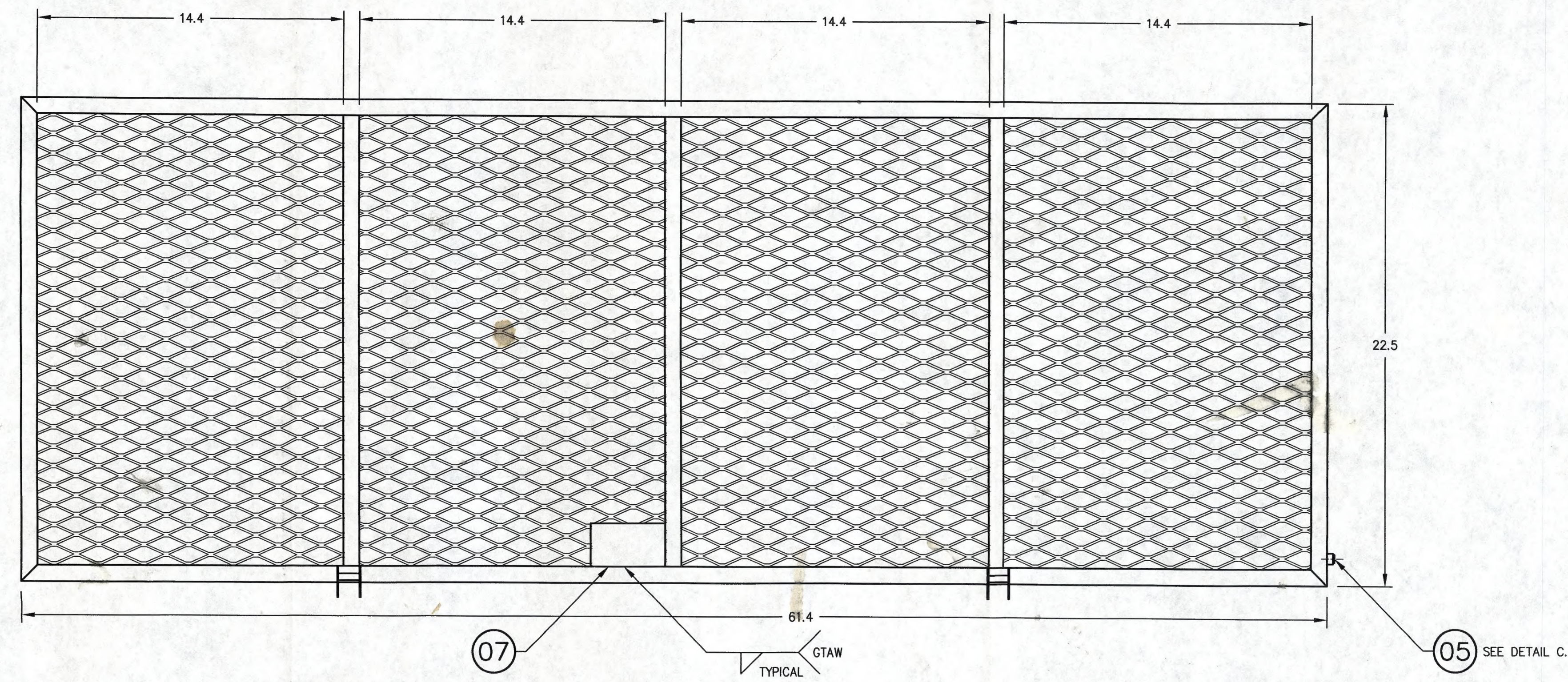
01 BASKET BODY ASSEMBLY

- NOTES:
1. FASTEN MESH TO BASKET AFTER ASSEMBLY OF BASKET. MESH TO BE ATTACHED TO THE INNER SURFACE OF THE BARREL OF THE BASKET. MESH COVERING THE ENDS TO BE BENT INWARD AT EDGS AND WELDED TO INNER EDGE OF THE END HOOP.
 2. REMOVE ALL BURRS AND SHARP EDGES.
 3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO AMS 64/A.
 4. THOROUGHLY DEGREASE ALL PARTS, PRIME, AND PAINT WHITE.

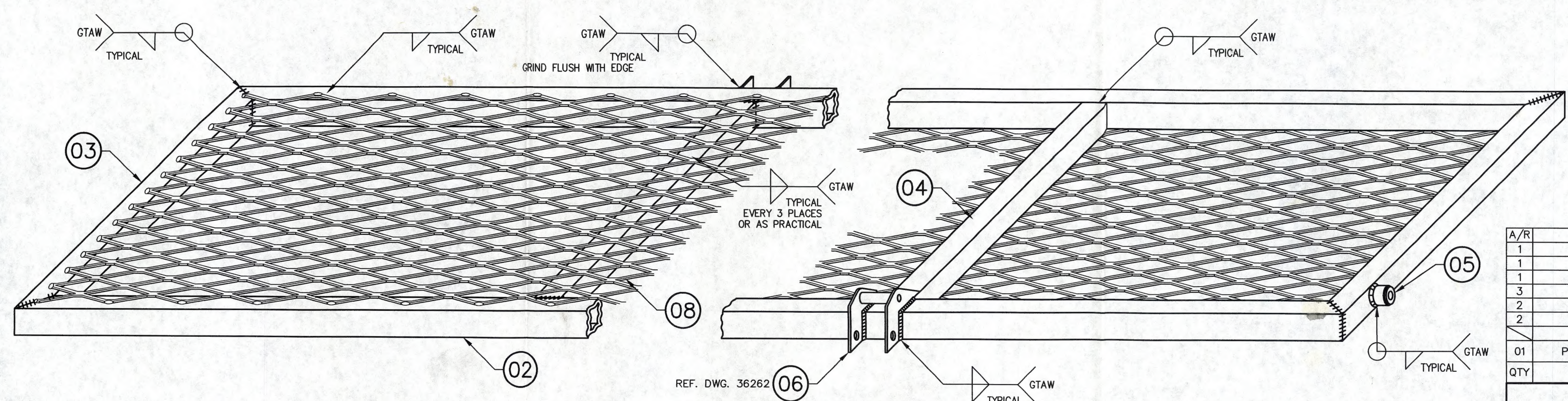
A/R	3/4-16F	09	MESH	STEEL	COMMERCIAL	
1	49215-01	08	SPACER			
1	36262-01	07	HANDLE BRACKET ASSEMBLY			
4	77625-01	06	SPINE			
2	49212-01	05	RIM			
2	77624-01	04	RIM			
3	50510-01	03	HOOP			
2	77621-01	02	ATTACHMENT HOOP			
	77611-01	01	BASKET BODY ASSEMBLY			
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

QTY			LIST OF MATERIALS			
	APPROVALS		DATE			
	DRAWN: JEFF CLARKE		30 NOV 2007			
	CHECKED: E. BURGAIN					
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			EUROCOPTER AS350 SERIES QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY			
		SCALE 1 : 4		DWG. SIZE	DWG. NO.	REV.
		SHEET 1 OF 1		A1	77611	0

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	*	*	*



- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.



A/R	3/4-16F	08	MESH					
1	36204-10	07	PLACARD BRACKET					
1	36262-01	06	UPPER HANDLE BRACKET ASSY					
1	49216-01	05	SPACER					
3	49213-01	04	LID BRACE					
2	49212-01	03	RIM					
2	77624-01	02	RIM					
	77612-01	01	BASKET LID ASSEMBLY					
Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE		
QTY	LIST OF MATERIALS							
<div><div>APPROVALS</div><div>DATE</div></div> <div>DRAWN: JEFF CLARKE30 NOV 2007</div> <div>CHECKED: E. BURGOIN</div> <div>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1</div>				AERO DESIGN LTD.				
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				EUROCOPTER AS350 SERIES QUICK RELEASE CARGO BASKET BASKET LID ASSEMBLY				
				SCALE 1 : 4		DWG. SIZE	DWG. NO.	REV.
				SHEET 1 OF 1		A1	77612	0